

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-004771**Date Inspected:** 13-Nov-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1330**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2230**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

<b>CWI Name:</b>	NA	<b>CWI Present:</b>	Yes	No			
<b>Inspected CWI report:</b>	Yes	No	N/A	<b>Rod Oven in Use:</b>	Yes	No	N/A
<b>Electrode to specification:</b>	Yes	No	N/A	<b>Weld Procedures Followed:</b>	Yes	No	N/A
<b>Qualified Welders:</b>	Yes	No	N/A	<b>Verified Joint Fit-up:</b>	Yes	No	N/A
<b>Approved Drawings:</b>	Yes	No	N/A	<b>Approved WPS:</b>	Yes	No	N/A
				<b>Delayed / Cancelled:</b>	Yes	No	N/A
<b>Bridge No:</b>	34-0006	<b>Component:</b>	OBG Fabrication				

**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector, Mr. Paul Dawson, arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China, for the purpose of monitoring welding and fabrication of the San Francisco / Oakland Bay Bridge (SFOBB) components. The QA Inspector observed the following:

**Heavy Bay #3**

This QA Inspector performed random final visual and magnetic particle (MT) inspections of the closed rib stiffener welds of deck panels DP117-002 and DP306-001. The QA Inspector observed ZPMC and ABF representatives had completed visual inspections of these welds and ZPMC had performed magnetic particle inspections of the welds and the welds of these deck panels have been identified as being acceptable on the yellow inspection status tag that is attached to each of the deck panels. The QA Inspector randomly observed the welds appear to comply with project specifications. The QA Inspector documented the final visual inspections on the yellow inspection status tags that are attached to each of the deck panels. See the TL6028 Magnetic Particle Test Report for additional information.

**OBG Assembly Bay #2**

The QA Inspector performed ultrasonic inspection of completed welds on deck panel DP110-002 to locate potentially cracked tack weld locations in the location where ZPMC had removed the diaphragm plate. Yesterday ZPMC removed a diaphragm plate that covered the areas that were ultrasonically inspected today. A total of eight

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welds were inspected and five of the welds that this Inspector inspected require additional evaluations with the phased array ultrasonic technique to determine if the welds contain cracks. The results of this inspection have been submitted for ultrasonic phased array inspections.

### Summary of Conversations:

See above.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Ady Velasco 13816942685, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Dawson,Paul	Quality Assurance Inspector
<b>Reviewed By:</b>	Carreon,Albert	QA Reviewer

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